

Work Order ID 117633

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117633

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Item ID: D5046-043

Revision ID:

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 4/28/14 Start Qty: 1.00

Required Date: 4/29/14 Req'd Qty: 1.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5046

A

110

Weld per dwg A/R Aluminum rod Batch: M123728 0.00

110

Large Fab

Memo

0.00

Large Fab

WELD D4410-7 to D5046-3 AS PER DWG

8 B 14-57

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

(8) 14-05-03 DAS
9
9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

(8) 14-05-03 DAS
9
9-89

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Item ID: D5046-043

Revision ID:

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 4/28/14 Start Qty: 1.00 ***1***

Required Date: 4/29/14 Req'd Qty: 1.00 ***1***

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

Issue P/O: 24145
Black Anodize as per Dwg D5046
C OF C REQUIRED

0.00

CL 14/05/09 8

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

C OF C REQUIRED

0.00

14/04/13 8

160

QC6- Inspect dimensions to drawing

0.00

160

QC

Memo

Quality Control

0.00

DAS

27

9-89

M/S/B

8

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0.00

14/5/14 ⑧

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Item ID: D5046-043
 Revision ID:
 Item Name: Co-Pilot Collective Head Assembly (212)
 Start Date: 4/28/14 Start Qty: 1.00 *1*
 Required Date: 4/29/14 Req'd Qty: 1.00 *1*
 Reference:

Accept ***N900040100*** Setup Start ***NS1***
 Stop ***NS2***
 Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____
 QC: _____ Date: _____

Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description
200	QC21- Final Inspection - Work Order Release
200	
QC	Memo
Quality Control	

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00							
0.00							

MLJ 14-05-15
 MF 14-5-15

Picklist Print

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Work Order ID: 117633

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Parent Item: D5046-043

D5046-043

Parent Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 4/28/14

Required Date: 4/29/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4410-7

Manufactured No

Each 4.0000

1

D4410-7

Conduit

14-5-7

117557 x 8

Location

Loc Qty

Loc Code

WA002

4

102040

4

D5046-3

Manufactured No

Each 0.0000

1

D5046-3

Co-Pilot Collective Head

90296A108

Purchased No

Each 302.0000

5

90296A108

Heli-Coil Insert

FF 14-05-14

Location

Loc Qty

Loc Code

ST391

302

m127878

52

m128972

250

MS171539

Purchased No

Each 27.0000

1

MS171539

Pin

FF 14-05-14

Location

Loc Qty

Loc Code

ST331

7

123183

7

ST332

20

m128799

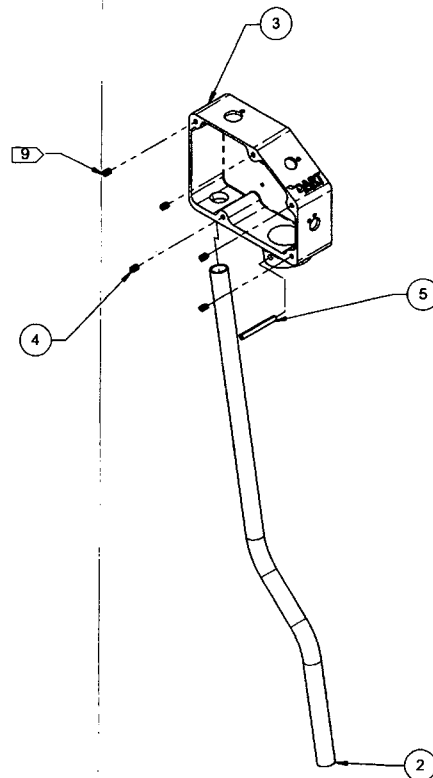
20

MS171599
Pin

Qty 1

Batch: 12383

ITEM	QTY	P/N	DESCRIPTION
1	X	D5046-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-7	CONDUIT
3	1	D5046-3	CO-PILOT COLLECTIVE HEAD
4	5	90296A108	HELI-COIL INSERT (6-32 X 0.276)
5	1	MS171599	PIN



w/o 167633

D5046-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5046-043 WELDING DETAIL

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5046	SHEET 2 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
DATE	14.01.22	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2014-04-04



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24145**

Purchase Order Date 5/9/2014

PO Print Date 5/13/2014

Page Number 1 of 5

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	116449	D5046-047 CO-PILOT HEAD ASSEMBLY	5/21/2014 Yes 5/21/2014		3.00	\$6.25	\$18.75
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/IC/II/IIB CLASS RUSH ORDER						
	Line Total:						\$18.75
2	117633	D5046-043 CO-PILOT HEAD ASSEMBLY	5/21/2014 Yes 5/21/2014		8.00	\$6.25	\$50.00
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB/IC/II/IIB CLASS RUSH ORDER						
	Line Total:						\$50.00

Note:

5/13/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63037

Date: 13-May-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description	Rev:	
1 lot	Part: ASST 3 PCS D5046-047 (6.25) 12 PCS D5046-043 (6.25) <i>84y</i> BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 PRICE IS PER PIECE Job: 20140286	PO: 24145 Line:	
<p align="center">Certificate of Conformance</p> <p>A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.</p> <p align="center">ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY</p> <p>DATE: <u>13/05/14</u></p> <p>CERTIFIED SIGNATURE: <u><i>m</i></u></p> <p>RECEIVER SIGNATURE: _____</p>			